

Work Order ID 80091

February-09-12 4:29:45 PM

80091

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Item ID: D2970-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 09/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2970	Rev A

100 FLOW WATER JET 0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2970 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

1016-040

B12-3-5

8

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

0.00

Quality Control

B12-3-5

120 QC8- Inspect parts - second check 0.00

120

QC

Memo

0.00

Quality Control

5713/06

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2970-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 09/02/2012 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 23/02/2012 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00							
130	Brake NC	0.00							
Brake NC	Memo	0.00							
	Debur and form on brake using DT8178 and DT8261 as per Dwg D2970								

SB 12/03/07

140	QC5- Inspect part completeness to step on W/O	0.00							
140	QC	0.00							
Quality Control	Memo								

SB 12/03/07

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150	Powdercoat	0.00							
Powder Coating	Memo								
	START TIME: 4:05 320°F OVEN TEMPERATURE:								
	FINISH TIME: 4:35								

MC19 489

8 QMK SP 12/03/07

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 09/02/2012 **Start Qty:** 8.00 ***g***

Cust Item ID:

Required Date: 23/02/2012 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

160

OC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *HP2* 0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release	0.00
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180

OC


Memo

0.00

Quality Control

8x d H 4103/09

8 ~~2~~ (29) ~~11/2~~ 03/09

12/3/12 

ME
12-03-09

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 80091

80091

Parent Item: D2970-3

D2970-3

Parent Item Name: Wearplate

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B01.06.07 Added Material and Tool number SM/EC
IPP C 08.09.03 Waterjet EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S19GA

Purchased

No

100

sf

0.0000

1.25

10.52632

M1010S19GA

**

1010/1025 SHEET .040

1010 .040 116791

M 116791

8

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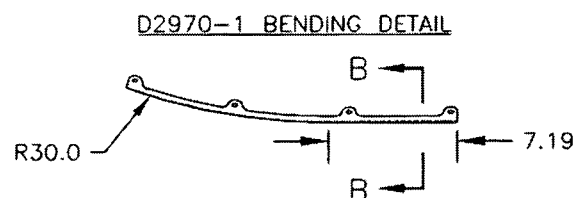
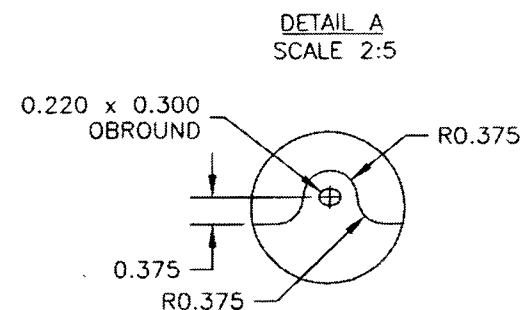
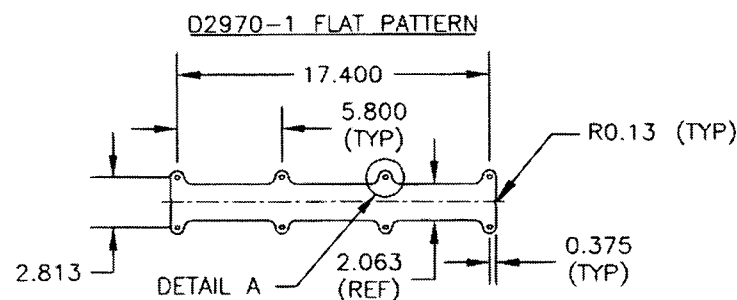
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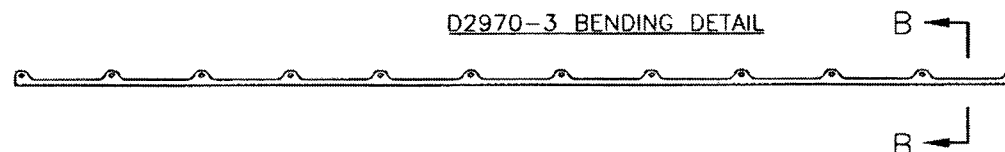
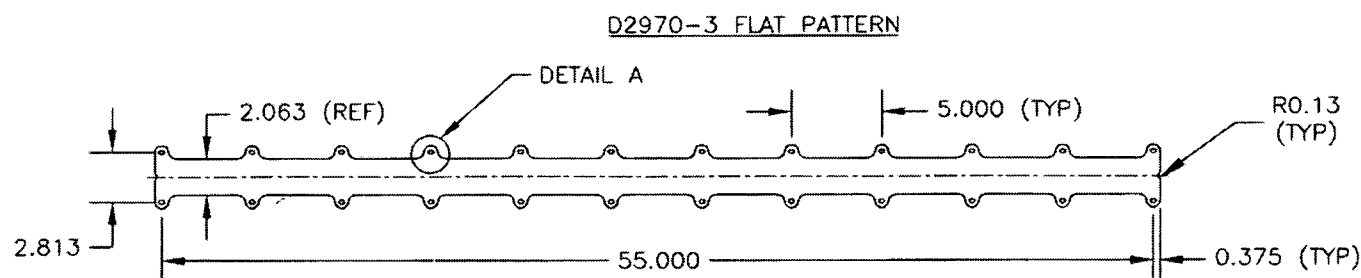
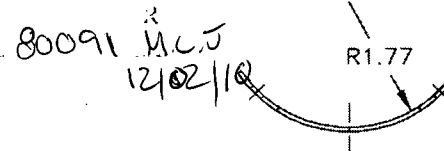
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
RF	RF	BELLEUE, WA
CHECKED	APPROVED	DRAWING NO.
		D2970
DATE	TITLE	REV. A
00.03.10	WEARPLATE	SHEET 1 OF 1
SCALE		
1:10		



SECTION B-B
SCALE 2:5



BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

RELEASED
00.05.11

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